



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE117-68021W9
Job Sheet 185208



Part No: RBE117-68021W9

Job Qty: 5 ea

Part Name: Pusher



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-68021W9 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Machining-3		Free 18-11-9
110	Lathe Conv	5 pcs	11/12/18	11/12/18	0.00	1.67	Lathe Conv-1		Free 18-11-12
120	QC	5 pcs	11/12/18	11/12/18	0.00	0.00	QC2 Machining-4		Free 18-11-12
130	QC	5 pcs	11/12/18	11/12/18	0.00	0.00	QC8 Machining-4		Free 18-11-12
150	Outsource	5 pcs	11/12/18	11/12/18			GRO002-VC	10	Free 18-11-14
160	Packaging	5 pcs	11/12/18	11/12/18	0.00	0.00	Packaging2		NOV 19 2018
170	QC	5 pcs	11/12/18	11/12/18	0.00	0.00	QC6		38
180	Packaging	5 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-1		ML 3-89
190	QC21-FG	5 Ea	11/12/18	11/12/18	0.00	0.00	QC21		DAS NOV 21 2018

Part Op 110 - 1-Machine as per DWG. 2-Deburr
Descriptions: 150 - -Issue P/O to GROUPE ALTECH; PO 041720 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.000	AISI 4140 Quenched & Tempered Steel Round Bar 1.000" Dia.	.9150 ft (.183 ea)	90-Start up Operation	5093068

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.000	1	30	0



Container No: S126504



Part: RBE117 - 68021W9

Job No: 185208

Serial No/Batch: S126504

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 11/09/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ions

not be found.

Plex 10/24/18 8:26 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

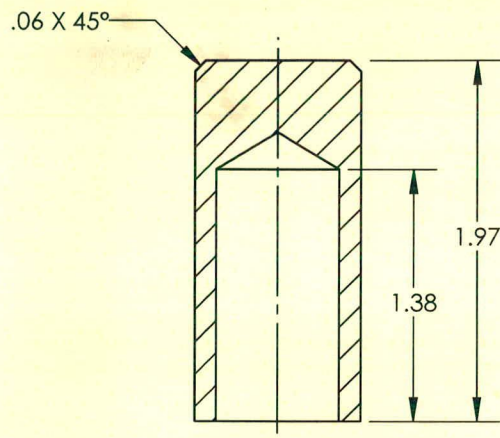
QA Closed: _____ Date: _____

Work Order update only ☐

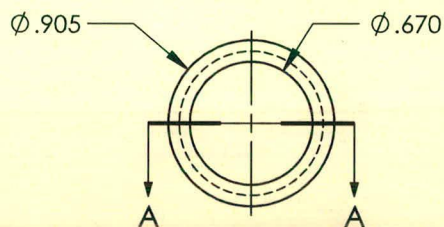
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		RELEASED FOR PRODUCTION.			10/10/2016	SM JAG



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185208 MJS
18-10-24



NOTES:
REF. AIRBUS T/N: 117-68021W9.

DART AEROSPACE	
TITLE PUSHER	
DWG NO. RBE117-68021W9	REV 1
MAT'L 4140/4142 HEAT RC 28-34 TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2 REV D	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: MACKOVJAK CHECKED: DUERFELDT OPPS APPR: ANDERSON	QA APPR: LINDSAY APPROVED: GILBERT
USED ON MODEL H145, EC145, EC645, H145M	
SCALE 1:1	DATE 7/21/2016
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	PUSHER	4140/4142		1



Dart Aerospace Ltd.
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K6A 1K7
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PURCHASE ORDER **PO041720**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041720
PO Date: 11/14/18
Due Date: 11/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60

Freight Terms:

Special Comments: ** Please confirm dates on line items **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178973	RBE703A94-1130-01-33	Adjuster -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1: MIL-C-16173 Grade 4 -Certificate of Conformity is required	Firmed	-	11/17/18	45 pcs	0 pcs	45 pcs	\$2.26415/pcs	\$101.89
							45 X	NOV 19 2018			
2	185208	RBE117-68021W9	Pusher -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	11/28/18	5 pcs	0 pcs	5 pcs	\$2.26415/pcs	\$11.32
							5 X	NOV 19 2018			

DAS
38
9-89

24
30
10



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PURCHASE ORDER **PO041720**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	186188	RBEM652V3002101-M-9	Bar Handle Nut -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/28/18	3 pcs	0 pcs	3 pcs	\$2.26415/pcs	\$6.79
Grand Total:										\$120.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/14/18 12:44 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014457-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014457- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Nov-2018		Jessie Boisvert		041720 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE703A94-1130-01-33 Rev. ✓	RBE703A94-1130-01-33 BLACK OXIDE COATING: MIL-C-13924 CLASS 1: MIL-C-16173, GRADE 4	BLACK-OXIDE CH	45	45 ✓	0	0	0
2	RBE117-68021W9 Rev. ✓	RBE117-68021W9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	5	5 ✓	0	0	0
3	RBEM652V3002101-M-9 Rev. ✓	RBEM652V3002101-M-9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	3	3 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

